

## SOME LIKE IT HOT.

The centrepiece of a TIG welding device is the optimum ignition and control. That makes welding devices real perfectionists: they can handle all metals from 0.3 mm on with direct or alternating current, depending on the material. Your advantage: They are so good at handling the concentrated splash-free electric arc, that bother-

some reworking is now a thing of the past. Metabo welding systems are produced as highly dependable tools: Only after successfully passing all air condition, dust chamber and vibration tests and then being checked again thoroughly, do they leave our factory.

e.g. TIG 170 AC/DC



**COMMON FEATURES**

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- "HF ignition" for contact-free ignition of the TIG electric arc
- 2/4-cycle control for comfortable work
- Outstanding ignition characteristics even with minimal welding currents
- Infinitely adjustable current rise time "Upslope" for even heating up of the material
- "Automatic finishing device": infinitely adjustable welding current reduction for optimum welded end
- Continuously adjustable gas post flow time for perfect gas management
- Switchable electrode functions with automatic hot start, anti-stick alternately with and without arc force regulation for perfect, even welding results without sticking
- Large, ergonomic and protected control elements for optimum adjustment even with gloves

- Digital welding current display with automatic nominal and actual value changeover
- Connection for optional hand or foot remote control
- Temperature-dependent fan control: reduced fan noise, dirt and energy consumption
- Robust metal housing
- Housing with protection class IP 23C for safe, rough construction site application
- "Multi-function shoulder strap": for light and practical device transport
- Removable torch and earth cable - Connection via large cable bushes
- Removable gas connection line for convenient transport
- "S-mark": approved for welding even in narrow welding spaces with increased electrical danger
- CE-inspected



WIG 170 DC



WIG 170 DC Set

	Inert Gas Welding System WIG 170 DC	Inert Gas Welding System WIG 170 DC Set
<b>Comparative device characteristics</b>		
Mains voltage	230 V	230 V
Open circuit voltage	85 V	85 V
Infinitely variable setting range TIG	5 - 170 A	5 - 170 A
Infinitely variable setting range E	5 - 140 A	5 - 140 A
Maximum power input E/TIG	6 kVA/4,4 kVA	6 kVA/4,4 kVA
Maximum duty cycle E/TIG at 40°C	40 %/40 %	40 %/40 %
100% duty cycle E/TIG at 40°C	90 A/110 A	90 A/110 A
Weldable electrodes up to	3,25 mm	3,25 mm
Weldable material thickness	0,3 - 6 mm	0,3 - 6 mm
Fuse protection for 230 V	T 16 A	T 16 A
Dimensions L x W x H	400 x 210 x 240 mm	400 x 210 x 240 mm
Weight	11,4 kg	11,4 kg
<b>Standard equipment</b>		Torch 4 m, earth cable 35 mm <sup>2</sup> , 5 m, pressure reducer with content and flow manometer
Type	WIG 170 DC	WIG 170 DC Set
Order no.	0021017100	0021917100

## COMMON FEATURES

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- "HF ignition" for contact-free ignition of the TIG electric arc
- 2/4-cycle control for comfortable work
- Switchable lift arc function for safe TIG ignition in computer-controlled systems
- Outstanding ignition characteristics even with minimal welding currents
- Infinitely adjustable second current for protecting the material from over-heating
- "Automatic finishing device": infinitely adjustable welding current reduction for optimum welded end
- Continuously adjustable gas post flow time for perfect gas management
- Frequency control during TIG-AC welding adjustable for a stable electric arc
- Balance control during TIG-AC welding adjustable for ideal fusion penetration
- Switchable electrode function with automatic hot start, arc force and anti-stick for perfect, even welding results without sticking
- Electrode function also with alternating current
- Large, ergonomic and protected control elements for optimum adjustment even with gloves
- Digital welding current display with automatic nominal and actual value changeover
- Connection for optional hand or foot remote control
- Temperature-dependent fan control: reduced fan noise, dirt and energy consumption
- Robust metal housing
- Housing with protection class IP 23C for safe, rough construction site application
- "Multi-function shoulder strap": for light and practical device transport
- Removable torch and earth cable - Connection via large cable bushes
- Removable gas connection line for convenient transport
- "S-mark": approved for welding even in narrow welding spaces with increased electrical danger
- Switchable automatic test function for testing the "S-mark"
- CE-inspected



**WIG 170 AC/DC**



**WIG 170 AC/DC Set**

	<b>Inert Gas Welding System WIG 170 AC/DC</b>	<b>Inert Gas Welding System WIG 170 AC/DC Set</b>
<b>Comparative device characteristics</b>		
Mains voltage	230 V	230 V
Open circuit voltage	85 V	85 V
Infinitely variable setting range TIG	5 - 170 A	5 - 170 A
Infinitely variable setting range E	5 - 140 A	5 - 140 A
Maximum power input E/TIG	5,5 kVA/4,8 kVA	5,5 kVA/4,8 kVA
Maximum duty cycle E/TIG at 40°C	40 %/40 %	40 %/40 %
100% duty cycle E/TIG at 40°C	80 A/110 A	80 A/110 A
Weldable electrodes up to	3,25 mm	3,25 mm
Weldable material thickness	0,3 - 6 mm	0,3 - 6 mm
Fuse protection for 230 V	T 16 A	T 16 A
Dimensions L x W x H	480 x 260 x 320 mm	480 x 260 x 320 mm
Weight	22,1 kg	22,1 kg
<b>Standard equipment</b>		Torch 4 m, earth cable 35 mm <sup>2</sup> , 5 m, pressure reducer with content and flow manometer
Type	<b>WIG 170 AC/DC</b>	<b>WIG 170 AC/DC Set</b>
Order no.	0021017200	0021917200

## FOR TIG WELDING SYSTEMS

## Welding torches



Torch type	Length m	Suitable for	Order no.
SR 26	4	WIG 170 DC, WIG 170 AC/DC	0902019073
SR 26	8	WIG 170 DC, WIG 170 AC/DC	0902019090

## FOR TIG WELDING TORCH SR

## Accessory box

Accessory box SR 18/SR 26/26 V  
Consisting of:

Tungsten electrode 1.6 x 175 mm, green WP 20  
 Tungsten electrode 2.4 x 175 mm, green WP 20  
 Tungsten electrode 3.2 x 175 mm, green WP 20  
 Tungsten electrode 1.6 x 175 mm, green WP 20  
 Tungsten electrode 2.4 x 175 mm, green WP 20  
 Tungsten electrode 3.2 x 175 mm, green WP 20  
 Clamping sleeve 1.6 mm  
 Clamping sleeve 2.4 mm  
 Clamping sleeve 3.2 mm  
 Clamping sleeve housing 1.6 mm  
 Clamping sleeve housing 2.4 mm  
 Clamping sleeve housing 3.2 mm  
 Ceramic gas nozzle size 5, Ø 8.0 mm  
 Ceramic gas nozzle size 6, Ø 9.5 mm  
 Ceramic gas nozzle size 7, Ø 11.0 mm  
 Torch cap long  
 Torch cap short  
 Carry case

Order no.

0902014500

## Clamping sleeve housing



Diameter mm	Suitable for	Order no.
1	SR 17/18/26	1327127132
1,6	SR 17/18/26	1327127140
2,4	SR 17/18/26	1327127159
3,2	SR 17/18/26	1327135410
4	SR 17/18/26	1327148431

## Ceramic gas nozzles



Size	Diameter mm	Version	Suitable for	Order no.
Size 4	6,5	Long	SR 17/18/26	1327180505
Size 5	8	Long	SR 17/18/26	1327127876
Size 6	9,5	Long	SR 17/18/26	1327127175
Size 7	11	Long	SR 17/18/26	1327127884
Size 8	12,5	Long	SR 17/18/26	1327135402

## Torch caps



Version	Suitable for	Order no.
Long	SR 17/18/26	1327127230
Short	SR 17/18/26	1327127248

## Clamping sleeves



Diameter mm	Suitable for	Order no.
1	SR 17/18/26	1327127078
1,6	SR 17/18/26	1327127086
2,4	SR 17/18/26	1327127094
3,2	SR 17/18/26	1327135429
4	SR 17/18/26	1327148423

# ACCESSORIES FOR TIG WELDING SYSTEMS

## FOR TIG WELDING TORCH MISTRAL

Accessory box				
				Order no.
	<b>Accessory box MISTRAL/TORNADO</b>		0902019316	
	Consisting of:			
	Tungsten electrode 1.6 mmX175 mm, grey WC 20			
	Tungsten electrode 2.4 mmX175 mm, grey WC 20			
	Tungsten electrode 3.2 mmX175 mm, grey WC 20			
	Tungsten electrode 4.0 mmX175 mm, grey WC 20			
	Rod holder 1.6 mm			
	Rod holder 2.4 mm			
	Rod holder 3.2 mm			
	Rod holder 4.0 mm			
	Ceramic gas nozzle size 7.5 Ø 7.5 mm			
	Ceramic gas nozzle size 10 Ø 10.0 mm			
	Ceramic gas nozzle size 13 Ø 13.0 mm			
	Torch cap long			
	Torch cap short			
	Carry case			
Rod holder				
				
Diameter mm	Version	Suitable for	Order no.	
1,6	Long	Mistral/Tornado	1327618225	
2,4	Long	Mistral/Tornado	1327618233	
3,2	Long	Mistral/Tornado	1327618241	
4	Long	Mistral/Tornado	1327618292	
1,6	Short	Mistral/Tornado	1327618250	
2,4	Short	Mistral/Tornado	1327618268	
3,2	Short	Mistral/Tornado	1327618276	
4	Short	Mistral/Tornado	1327618284	
Ceramic gas nozzles				
				
Size	Diameter mm	Version	Suitable for	Order no.
Size 7.5	7,5	Long	Mistral/Tornado	1327618306
Size 10	10	Long	Mistral/Tornado	1327618314
Size 13	13	Long	Mistral/Tornado	1327618322
Size 16	16	Long	Mistral/Tornado	1327618330
Size 7.5	7,5	Short	Mistral/Tornado	1327618349
Size 10	10	Short	Mistral/Tornado	1327618357
Size 13	13	Short	Mistral/Tornado	1327618365
Torch caps				
				
Version	Suitable for	Order no.		
Short	Mistral/Tornado	1327618390		
Long	Mistral/Tornado	1327618403		

## OTHER ACCESSORIES FOR TIG WELDING SYSTEMS

Order no.			
0902014829			
<b>Hand remote control</b> Cable length: 5 m			
			
Cable length m	Version	Order no.	
5	Aluminium	0902019391	
<b>Foot remote control</b>			
Order no.			
1327022381			
<b>Welding site equipment no. 7</b> Consisting of welding cable, earth cable, welding shield, wire brush and deslagging hammer Cable diameter: 25 mm <sup>2</sup> Length: 3 m Suitable for: WIG 170 DC, WIG 170 AC/DC			
			
Maximum welding current A	Order no.		
<b>Earth clamps</b>			
200	0902027467		
400	0902027475		
<b>Rod holder</b>			
200	0902027440		
300	0902027459		
Cable diameter mm <sup>2</sup>	Length m	Suitable for	Order no.
<b>Earth cable</b>			
25	3	WIG 170 DC, WIG 170 AC/DC	0902008365
<b>Electrode cable</b>			
35	3	WIG 170 DC, WIG 170 AC/DC	0902007180
<b>Other accessories for welding systems</b> See page 346/347			
<b>Tungsten electrodes</b> See page 347			
			
<b>Stick electrodes</b> See page 347			
			

## GIVE THEM SOME GAS.

Simple handling and excellent thin sheet properties – those are the advantages of MIG/MAG welding. Depending on the material, various gases are supplied. You can use MIG (Metal Inert Gas) to process aluminium and aluminium alloys without problems. The MAG (Metal Active Gas) method is suitable for construction, tank and pipe steel

from approx. 0.5 mm on as well as for stainless steel and high alloy steel. A welding system for high demands – our engineers have taken everything into consideration: from the adjustable burn back time to the multi-handle for the simple transportation of the device.

e.g. MIG/MAG 250/60 XT

### Smart intelligence

*State-of-the-art processor control for simple operation and ideal welding results.*

### Gasless and currentless welding wire threading

*– convenient, without loss of gas and safe. 2/4-cycle control for practical operation.*

*Adjustable automatic dot welding option for even welding results.*

**Rough and fine levels**  
for perfect adjustment to the material.

**230 V three-wire electrical socket with switch**  
*– ideal for connecting an angular grinder etc.*

**Robust welded housing construction (chassis).**

**Torch and earth cable**  
can be removed.



**5-year warranty on main transformer.**



**Rubber-coated storage surface**  
*– practical for accessories.*

**Multi-handle**  
for the easy transportation of the device and the practical storage of the welding site equipment.

**Vertical wire roller guide**  
with angular torch and wire outlet for ideal and even wire transport.

**Large device transport wheels** for easy and safe transport.

**"S mark"**  
Approved for welding even in narrow spaces with increased electrical risk.

## COMMON FEATURES

- Large control elements for optimum adjustment
- Copper coil with heat protection for long service life
- Welding wire holder for 0.8 kg and 5 kg rolls
- Mobile for easy transportation
- Variable gas bottle holder

- "S-mark": approved for welding in narrow welding spaces with increased electrical danger
- 5 year warranty on main transformer
- CE-inspected



....5 year warranty  
on main transformer



**MIG/MAG 140**

**MIG/MAG 160**

	Inert Gas Welding System <b>MIG/MAG 140</b>	Inert Gas Welding System <b>MIG/MAG 160</b>
<b>Comparative device characteristics</b>		
Mains voltage	230 V	230 V
Maximum power input at 230 V	5,1 kVA	5,3 kVA
Setting range (230 V)	30 - 140 A	30 - 160 A
Regulation	4 levels	4 levels
Weldable wire	0,6 - 0,8 mm	0,6 - 0,8 mm
Weldable material thickness	0,5 - 3 mm	0,5 - 4 mm
Maximum duty cycle at 25 °C	7 %	15 %
Maximum duty cycle at 40 °C	4 %	8 %
100% duty cycle at 25 °C		35 A
100% duty cycle at 40 °C		20 A
Fuse protection for 230 V	T 16 A	T 16 A
Dimensions L x W x H	590 x 260 x 420 mm	590 x 260 x 420 mm
Weight	21 kg	26,5 kg
<b>Standard equipment</b>	Torch SB 14/2 m fixed connection, earth cable, pressure reducer without manometer	Torch SB 14/2 m fixed connection, earth cable, pressure reducer without manometer
Type	MIG/MAG 140	MIG/MAG 160
Order no.	0271071507	0271071701

**COMMON FEATURES**

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- Gasless and currentless welding wire threading - comfortable, gas-loss-free and safe
- Soft start for easy electric arc start
- Adjustable burn back time for practical electric arc restart
- 2/4-cycle control for practical operation
- Adjustable automatic point system for even welding results
- Large, ergonomic and protected control elements for optimum adjustment even with gloves
- Electronics dust-proof for rough applications
- Metal wire feed for safe wire transport
- Vertical wire roller guide with straight torch and wire outlet for optimum and even wire transport

- "Cooling duct": high duty cycle due to optimum cooling
- Robust welding housing construction (chassis)
- "Multigriff": for easy transportation of device and practical storage of welding site equipment
- Large device transport wheels for easy and safe transport
- Rubber-coated storage area - practical for accessories
- Variable gas bottle holder
- Removable torch and earth cable
- "S-mark": approved for welding in narrow welding spaces with increased electrical danger
- 5 year warranty on main transformer
- CE-inspected



....5 year warranty  
on main transformer



	Inert Gas Welding System MIG/MAG 150/20 XT	Inert Gas Welding System MIG/MAG 150/20 XT Set
<b>Comparative device characteristics</b>		
Mains voltage	230 V	230 V
Maximum power input at 230 V	5,8 kVA	5,8 kVA
Setting range (230 V)	30 - 150 A	30 - 150 A
Regulation	6 levels	6 levels
Weldable wire	0,6 - 0,8 mm	0,6 - 0,8 mm
Weldable material thickness	0,5 - 5 mm	0,5 - 5 mm
Maximum duty cycle at 25 °C	20 %	20 %
Maximum duty cycle at 40 °C	15 %	15 %
100% duty cycle at 25 °C	50 A	50 A
100% duty cycle at 40 °C	50 A	50 A
Fuse protection for 230 V	T 16 A	T 16 A
Dimensions L x W x H	854 x 338 x 782 mm	854 x 338 x 782 mm
Weight	59,5 kg	59,5 kg
<b>Standard equipment</b>	Torch SB 14/3 m fixed connection, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer	Torch SB 14/3 m fixed connection, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, welding wire 0.8 mm/5 kg (G3Si1), adapter for 5 kg, gas bottle 10 litres mixed gas
Type	MIG/MAG 150/20 XT	MIG/MAG 150/20 XT Set
Order no.	0021031700	0021901700

## COMMON FEATURES

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- Gasless and currentless welding wire threading - comfortable, gas-loss-free and safe
- Soft start for easy electric arc start
- Adjustable burn back time for practical electric arc restart
- 2/4-cycle control for practical operation
- Adjustable automatic point system for even welding results
- Large, ergonomic and protected control elements for optimum adjustment even with gloves
- Electronics dust-proof rough applications
- Unique: switchable three-wire electrical socket 230 V - ideal for angle grinder etc.
- Metal 2-roller wire feed for safe wire transport even with long hose packets
- Vertical wire roller guide with angular torch and wire outlet for optimum and even wire transport
- Operation at 230 V and 400 V for universal use
- "Cooling duct": high duty cycle due to optimum cooling
- Robust welding housing construction (chassis)
- "Multigriff": for easy transportation of device and practical storage of welding site equipment
- Large device transport wheels for easy and safe transport
- Rubber-coated storage area - practical for accessories
- Variable gas bottle holder
- Removable torch and earth cable
- "S-mark": approved for welding in narrow welding spaces with increased electrical danger
- 5 year warranty on main transformer
- CE-inspected



....5 year warranty  
on main transformer



	Inert Gas Welding System MIG/MAG 170/30 XTC	Inert Gas Welding System MIG/MAG 170/30 XTC Set
<b>Comparative device characteristics</b>		
Mains voltage	230/400 V	230/400 V
Maximum power input at 400 V	6,7 kVA	6,7 kVA
Setting range (400 V)	60 - 170 A	60 - 170 A
Regulation	6 levels each	6 levels each
Weldable wire	0,6 - 0,8 mm	0,6 - 0,8 mm
Weldable material thickness	0,5 - 6 mm	0,5 - 6 mm
Maximum duty cycle at 25 °C	30 %	30 %
Maximum duty cycle at 40 °C	20 %	20 %
100% duty cycle at 25 °C	90 A	90 A
100% duty cycle at 40 °C	60 A	60 A
Fuse protection for 400 V	T 16 A	T 16 A
Dimensions L x W x H	854 x 338 x 782 mm	854 x 338 x 782 mm
Weight	68,5 kg	68,5 kg
<b>Standard equipment</b>	Torch SB 15/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, connection adapter 230 V/400 V	Torch SB 15/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, connection adapter 230 V/400 V, welding wire 0.8 mm/5 kg (G3Si1), adapter for 5 kg, gas bottle 10 litres mixed gas
<b>Type</b>	MIG/MAG 170/30 XTC	MIG/MAG 170/30 XTC Set
<b>Order no.</b>	0021031900	0021901900

**COMMON FEATURES**

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- Gasless and currentless welding wire threading - comfortable, gas-loss-free and safe
- Soft start for easy electric arc start
- Adjustable burn back time for practical electric arc restart
- 2/4-cycle control for practical operation
- Adjustable automatic point system for even welding results
- Large, ergonomic and protected control elements for optimum adjustment even with gloves
- Electronics dust-proof rough applications
- Unique: switchable three-wire electrical socket 230 V - ideal for angle grinder etc.
- Metal 2-roller wire feed for safe wire transport even with long hose packets
- Rough and fine levels for optimum material adjustment

- Vertical wire roller guide with angular torch and wire outlet for optimum and even wire transport
- "Cooling duct": high duty cycle due to optimum cooling
- Robust welding housing construction (chassis)
- "Multigriff": for easy transportation of device and practical storage of welding site equipment
- Large device transport wheels for easy and safe transport
- Rubber-coated storage area - practical for accessories
- Variable gas bottle holder
- Removable torch and earth cable
- "S-mark": approved for welding in narrow welding spaces with increased electrical danger
- 5 year warranty on main transformer
- CE-inspected



	Inert Gas Welding System MIG/MAG 200/40 XT	Inert Gas Welding System MIG/MAG 200/40 XT Set
<b>Comparative device characteristics</b>		
Mains voltage	400 V	400 V
Maximum power input at 400 V	7 kVA	7 kVA
Setting range (400 V)	30 - 200 A	30 - 200 A
Regulation	2 x 6 levels	2 x 6 levels
Weldable wire	0,6 - 1 mm	0,6 - 1 mm
Weldable material thickness	0,5 - 8 mm	0,5 - 8 mm
Maximum duty cycle at 25 °C	40 %	40 %
Maximum duty cycle at 40 °C	30 %	30 %
100% duty cycle at 25 °C	120 A	120 A
100% duty cycle at 40 °C	100 A	100 A
Fuse protection for 400 V	T 16 A	T 16 A
Dimensions L x W x H	954 x 384 x 882 mm	954 x 384 x 882 mm
Weight	91 kg	91 kg
<b>Standard equipment</b>	Torch SB 25/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer	Torch SB 25/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, welding wire 0.8 mm/5 kg (G3Si1), adapter for 5 kg, gas bottle 10 litres mixed gas
Type	MIG/MAG 200/40 XT	MIG/MAG 200/40 XT Set
Order no.	0021032200	0021902200

## COMMON FEATURES

- "Smart Intelligence": state-of-the-art processor control for easy operation and ideal welding results
- Gasless and currentless welding wire threading - comfortable, gas-loss-free and safe
- Soft start for easy electric arc start
- Adjustable burn back time for practical electric arc restart
- 2/4-cycle control for practical operation
- Adjustable automatic point system for even welding results
- Large, ergonomic and protected control elements for optimum adjustment even with gloves
- Electronics dust-proof rough applications
- Unique: switchable three-wire electrical socket 230 V - ideal for angle grinder etc.
- Metal 2-roller wire feed for safe wire transport even with long hose packets
- Rough and fine levels for optimum material adjustment
- Vertical wire roller guide with angular torch and wire outlet for optimum and even wire transport
- "Cooling duct": high duty cycle due to optimum cooling
- Robust welding housing construction (chassis)
- "Multigriff": for easy transportation of device and practical storage of welding site equipment
- Large device transport wheels for easy and safe transport
- Rubber-coated storage area - practical for accessories
- Variable gas bottle holder
- Removable torch and earth cable
- "S-mark": approved for welding in narrow welding spaces with increased electrical danger
- 5 year warranty on main transformer
- CE-inspected



....5 year warranty  
on main transformer



	Inert Gas Welding System MIG/MAG 250/60 XT	Inert Gas Welding System MIG/MAG 250/60 XT Set	Inert Gas Welding System MIG/MAG 300/45 XT	Inert Gas Welding System MIG/MAG 300/45 XT Set
<b>Comparative device characteristics</b>				
Mains voltage	400 V	400 V	400 V	400 V
Maximum power input at 400 V	8,9 kVA	8,9 kVA	12,1 kVA	12,1 kVA
Setting range (400 V)	30 - 250 A	30 - 250 A	30 - 300 A	30 - 300 A
Regulation	2 x 6 levels	2 x 6 levels	2 x 6 levels	2 x 6 levels
Weldable wire	0,6 - 1,2 mm	0,6 - 1,2 mm	0,6 - 1,2 mm	0,6 - 1,2 mm
Weldable material thickness	0,5 - 10 mm	0,5 - 10 mm	0,5 - 15 mm	0,5 - 15 mm
Maximum duty cycle at 25 °C	60 %	60 %	45 %	45 %
Maximum duty cycle at 40 °C	40 %	40 %	30 %	30 %
100% duty cycle at 25 °C	190 A	190 A	190 A	190 A
100% duty cycle at 40 °C	160 A	160 A	150 A	150 A
Fuse protection for 400 V	T 16 A	T 16 A	T 16 A	T 16 A
Dimensions L x W x H	954 x 384 x 882 mm	954 x 384 x 882 mm	954 x 384 x 882 mm	954 x 384 x 882 mm
Weight	102 kg	102 kg	104 kg	104 kg
<b>Standard equipment</b>				
	Torch SB 25/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer	Torch SB 25/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, welding wire 0.8 mm/5 kg (G3Si1), adapter for 5 kg, gas bottle 10 litres mixed gas	Torch SB 36/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer	Torch SB 36/3 m, earth cable, protective shield, wire brush, torch spray, pressure reducer with content and flow manometer, welding wire 1.0 mm/15 kg (G3Si1), gas bottle 10 litres mixed gas
Type Order no.	MIG/MAG 250/60 XT 0021032800	MIG/MAG 250/60 XT Set 0021902800	MIG/MAG 300/45 XT 0021033300	MIG/MAG 300/45 XT Set 0021903300

**FOR THE MIG/MAG INERT GAS  
WELDING SYSTEMS**
**Welding torches**

Torch type	Length m	Suitable for	Order no.
SB 14	3	MIG/MAG 150/20 XT	0902009922
SB 15	3	MIG/MAG 170/30 XTC, MIG/MAG 180/35 ETC, MIG/MAG 180/40 ETC, MIG/MAG 200/35 ET, MIG/MAG 210/40 ET	0902009949
SB 15	4	MIG/MAG 170/30 XTC, MIG/MAG 180/35 ETC, MIG/MAG 180/40 ETC, MIG/MAG 200/35 ET, MIG/MAG 210/40 ET	0902009957
SB 15	5	MIG/MAG 170/30 XTC, MIG/MAG 180/35 ETC, MIG/MAG 180/40 ETC, MIG/MAG 200/35 ET, MIG/MAG 210/40 ET	0902009965
SB 25	3	MIG/MAG 200/40 XT, MIG/MAG 250/60 XT, MIG/MAG 230/40 ET, MIG/MAG 230/60 ET, MIG/MAG 260/60 ET	0902008330
SB 25	4	MIG/MAG 200/40 XT, MIG/MAG 250/60 XT, MIG/MAG 230/40 ET, MIG/MAG 230/60 ET, MIG/MAG 260/60 ET	0902008349
SB 25	5	MIG/MAG 200/40 XT, MIG/MAG 250/60 XT, MIG/MAG 230/40 ET, MIG/MAG 230/60 ET, MIG/MAG 260/60 ET	0902008357
SB 36	3	MIG/MAG 300/45 XT	0902008411
SB 36	4	MIG/MAG 300/45 XT	0902008420
SB 36	5	MIG/MAG 300/45 XT	0902008438

**FOR MIG/MAG WELDING TORCHES****Gas nozzles**

Diameter mm	Version	Suitable for	Order no.
12	Conical	SB 14/15	1327045357
16	Cylindrical	SB 14/15	1327045349
16	Point nozzle	SB 14/15	1327045381
15	Conical	SB 25	1327045519
18	Cylindrical	SB 25	1327045500
18	Point nozzle	SB 25	1327045543
16	Conical	SB 36	1327064165
19	Cylindrical	SB 36	1327064157
20	Point nozzle	SB 36	1327064190

**Flow nozzles**

Diameter mm	For the welding of	Suitable for	Order no.
0,6	Steel/special steel	SB 14/15	1327045306
0,8	Steel/special steel	SB 14/15	1327045314

Diameter mm	For the welding of	Suitable for	Order no.
1	Steel/special steel	SB 14/15	1327045330
1,2	Steel/special steel	SB 14/15	1327056693
0,8	Aluminium	SB 14/15	1327009660
1	Aluminium	SB 14/15	1327009679
1,2	Aluminium	SB 14/15	1327009687
0,6	Steel/special steel	SB 25-41	1327056685
0,8	Steel/special steel	SB 25-41	1327045462
1	Steel/special steel	SB 25-41	1327045489
1,2	Steel/special steel	SB 25-41	1327045497
0,8	Aluminium	SB 25-41	1327009695
1	Aluminium	SB 25-41	1327009709
1,2	Aluminium	SB 25-41	1327009717

**Sets**

Order no.
Set 1 SB 14/15
1 x conical gas nozzle, 1 x cylindrical gas nozzle, 1 x spot gas nozzle, 2 x flow nozzle 0.6 mm, 2 x flow nozzle 0.8 mm, 1 x flow nozzle 1.0 mm
Set 2 SB 14/15
1 x conical gas nozzle, 1 x cylindrical gas nozzle, 1 x spot gas nozzle
Set 3 SB 14/15
1 x very conical gas nozzle, 1 x bottle-shaped gas nozzle
Set 4 SB 14/15
3 x conical gas nozzle
Set 5 SB 14/15
3 x cylindrical gas nozzle
Set 6 SB 14/15
1 x spot gas nozzle, 1 x nail welding nozzle
Set 7 SB 14/15
5 x flow nozzle 0.6 mm
Set 8 SB 14/15
5 x flow nozzle 0.8 mm
Set 9 SB 14/15
5 x flow nozzle 1.0 mm
Set 10 SB 14/15
5 x retaining spring
Set 12 SB 14/15
For aluminium/special steel, wire Ø 0.6-1.2 mm, 3 m 1 x cylindrical gas nozzle, each with 1 x flow nozzle 0.8 mm, 1.0 mm, 1.2 mm aluminium, 1 x polyamide core Ø 0.6-1.2 mm, 3 m, 1 x guide pipe for polyamide core

**Swan necks**

Order no.
SB 14
SB 15
SB 25
SB 36

Order no.
Gas nozzle carrier SB 14/15
Protective sleeve SB 14/15
Retaining spring SB 25
Nozzle stem SB 25
Nozzle stem SB 36
Gas distributor SB 36

SAWS

SPECIAL-PURPOSE  
MACHINESSYSTEMATIC  
ORGANISATION  
GARDENWOOD-PROCESSING  
TECHNOLOGYWATER-/PUMP  
TECHNOLOGYWELDING  
TECHNOLOGYCOMPRESSED  
AIR SYSTEMS

# ACCESSORIES FOR MIG/MAG WELDING SYSTEMS

## OTHER ACCESSORIES FOR MIG/MAG WELDING TORCHES

### Polyamide cores



Dia- meter mm	Length m	For the welding of	Suitable for	Order no.
0,6 - 0,8	3	Steel/special steel	SB 14	1327045195
0,6 - 1,2	3	Aluminium/ stainless steel	SB 15-41	1327144550
0,6 - 1,2	4	Aluminium/ stainless steel	SB 15-41	1327144541
0,6 - 1,2	5	Aluminium/ stainless steel	SB 15-41	1327144533

### Guide pipe for polyamide core



Order no.	
Guide pipe for polyamide core	1327045578

### Guide spirals



Dia- meter mm	Length m	For the welding of	Suitable for	Order no.
0,6 - 0,9	3	Steel	SB 15-36	1327064203
0,6 - 0,9	4	Steel	SB 15-36	1327064211
0,6 - 0,9	5	Steel	SB 15-36	1327064220
1 - 1,2	3	Steel	SB 15-36	1327064238
1 - 1,2	4	Steel	SB 15-36	1327064246
1 - 1,2	5	Steel	SB 15-36	1327064254

### Cleaning pincer



Order no.	
Cleaning pincer	0902027483

### Multiple spanner



Order no.	
Multiple spanner	1327045411

### Earth cable



Cable diameter mm <sup>2</sup>	Length m	Suitable for	Order no.
25	3	MIG/MAG 170/30 XTC, MIG/MAG 200/40 XT, MIG/MAG 250/60 XT	0902008365
35	5	MIG/MAG 300/45 XT	0902011293

### Earth clamps



Maximum welding current A	Order no.
200	0902027467
400	0902027475

### Gas-shielded welding wire



Material	Diameter mm	Weight kg	Delivery type	Order no.
G3Si1	0,6	0,8	Roller	4411088338
G3Si1	0,6	5	Roller	4411060905
G3Si1	0,8	5	Roller	4411060921
G3Si1	0,6	15	Roller	4411060913
G3Si1	0,6	15	Basket	4411154721
G3Si1	0,8	15	Roller	4411060930
G3Si1	0,8	16	Basket	4411141549
G3Si1	1	15	Roller	4411060948
G3Si1	1	15	Basket	4411141557
G3Si1	1,2	15	Roller	4411060956
G3Si1	1,2	15	Basket	4411154730
AlMg3	0,8	2	Roller	4411014555
AlMg3	1	6	Roller	4411003600

### Adapters for gas-shielded welding wire

Order no.	
Adapter ring for 5 kg roll	0902018158
Adapter for mesh wire spool	0902012630

## GENERAL ACCESSORIES FOR WELDING SYSTEMS

### Automatic protective screens

- Power supply via solar cells (no battery change)
- Permanent UV/IR protection
- Safe operation thanks to two independently operating sensors
- True Color recognition
- Supplementary comfortable terry towelling headband

Order no.
Automatic protective screen <b>Translight 2131</b> Dark level: DIN 11 Switching time: 0,0003 sek Switch sensitivity: 2 levels Brightening time: 0,2 sek Field of view: 98 x 40 mm Weight: 425 g

Order no.
Automatic protective screen <b>Translight 2200</b> Dark level: DIN 9-13 (infinitely variable) Switching time: 0,0003 sek Switch sensitivity: Infinitely Brightening time: 0,2 sek Field of view: 98 x 40 mm Weight: 425 g

## Welding shields



	Order no.
<b>Welding shield with glass DIN 9 and bright glass overlay</b> Glass DIN 9 and bright glass overlay	0902027840
<b>Welding shield with glass DIN 11, bright glass overlay and transparent glass</b> Welding glass DIN 11	0902005528
<b>Welding shield with glass DIN 11 and bright glass overlay as hood</b> Welding glass DIN 11	0902007164

## Welding glasses



	Order no.
<b>Welding glass 75x98 mm, dark DIN 11</b> Only for SB 160C/ SB 200CT	1321186455
<b>Welding glass 90x110 mm, dark, DIN 9</b>	0902027793
<b>Welding glass 90x110 mm, dark, DIN 11</b>	0902027807
<b>Welding glass 90x110 mm, bright</b>	0902027815
<b>Welding glass 40x110 mm, bright for transparency</b>	0902010661

## Pressure reducer



	Order no.
<b>Pressure reducer with content manometer and flow manometer</b>	0902031472
<b>Pressure reducer with content manometer, flow manometer and cut-off valve</b>	0902005293

## Torch spray



	Order no.
<b>Torch spray 150 ml</b>	1327038296
<b>Torch spray 400 ml, "Abicor Binzel"</b>	0902061150

## Wire brush



	Order no.
<b>Wire brush, 2-row</b>	0902027823

## Deslagging hammer



	Order no.
<b>Deslagging hammer</b>	0902027831

## Tungsten electrodes



Elec- trode colour	Diameter mm	Version	Packing unit	Order no.
Red	1	98% tungsten and 2% thorium oxide	10	0902027530
Red	1,6	98% tungsten and 2% thorium oxide	10	0902027521
Red	2,4	98% tungsten and 2% thorium oxide	10	0902027513
Grey	1	98% tungsten and 2% cerioxide	10	0902018484
Grey	1,6	98% tungsten and 2% cerioxide	10	0902018492
Grey	2,4	98% tungsten and 2% cerioxide	10	0902018506
Green	1	99.9% tungsten	10	0902027556
Green	1,6	99.9% tungsten	10	0902027564
Green	2,4	99.9% tungsten	10	0902027572

## Stick electrodes



Diameter mm	Length mm	Packing unit	Order no.
EN 499: E 350 RR 12 (DIN 1913: E 4322 RR6)			
1,6	250	25	0902027890
2	250	25	0902027904
2,5	350	25	0902027912
3,25	350	25	0902027920
2	250	175	0902027866
2,5	350	100	0902027874
3,25	350	125	0902027882
EN 499: E 380 RC 11 (DIN 1913: E 5132 R(C) 3)			
2,5	350	100	0902018883
3,25	350	125	0902018875
4	350	95	0902061169